



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3910-1

Job Sheet 171541



Part No: D3910-1

Job Qty: 30 ea

Part Name: Crosstube Lug



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/2/18

Job Tracking No:

Due Date: 2/16/18

Created By: Diane Baker

Type: Stock

Description:

Ship Via:

Dwg Rev. E **DAS 10 9-89**

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Purchasing	30 pcs		2/15/18	0.00	0.00	Purchasing		<i>AT 18/0408</i>
120	Packaging	30 pcs		2/15/18	0.00	0.00	Packaging2		<i>AT 18/02/00 DAS</i>
130	QC	30 pcs		2/15/18	0.00	0.00	QC6		<i>33 11</i>
140	HandFinish	30 pcs		2/15/18	0.00	0.41	HandFinish1		<i>9-89 9-89</i>
150	QC	30 pcs		2/15/18	0.00	0.00	QC7-2		<i>NIA DAS 33</i>
160	Powdercoat	30 pcs		2/16/18	0.00	0.53	Powdercoat1		<i>33</i>
170	QC	30 pcs		2/16/18	0.00	0.00	QC3		<i>9-89</i>
180	Packaging	30 pcs		2/16/18	0.00	0.00	Packaging3-2		<i>DAS 5RL</i>
190	QC21-SA	30 Ea		2/16/18	0.00	0.00	QC21		<i>21 FEB 14 2018</i>

Part Op 110 - ISSUE PO TO METEC, NOTE ALODINE AND PAINT AS PER QSI 005

Descriptions: 120 - Ensure C of C is attach

160 - START TIME: _____

P0038937

FEB 02 2018

p.B

57525

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2423	Lug Extrusion	3.9000 ft (.13 ea)	110-Purchasing	
D3910-1P	Crosstube Lug	30 pcs (1 ea)	110-Purchasing	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Purchasing	D2423	4	807	0
	D3910-1P	30	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Crosstube Lug	4.450Inches $\pm$ 0.030	4.480 4.420		
2	Crosstube Lug	1.380Inches $\pm$ 0.030	1.410 1.350		
3	Crosstube Lug	0.270Inches $\pm$ 0.030	0.300 0.240	reference	
4	Crosstube Lug	0.310Inches $\pm$ 0.030	0.340 0.280		
5	Crosstube Lug	0.735Inches $\pm$ 0.010	0.745	reference	

DART
AEROSPACE
S040569

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Crosstube Lug

PART NO: D3910-1

Original Serial #: S040569

Revision:

Operation: Purchasing

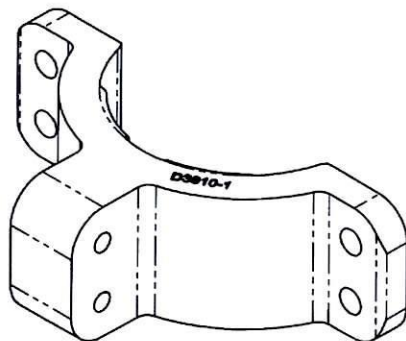
Change No:

Mfg Date: 02/08/18

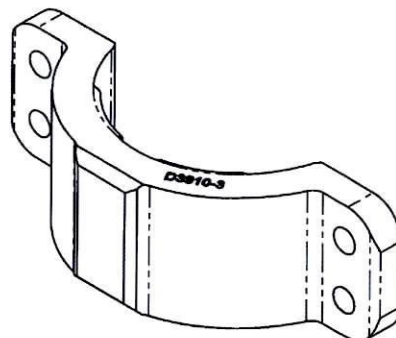
Job No: 171541

			0.725	
6	Crosstube Lug	2.200Inches ± 0.030	2.230 2.170	
7	Crosstube Lug	0.375Inches ± 0.010	0.385 0.365	
8	Crosstube Lug	0.191Inches + 0.005 - 0.001	0.196 0.190	Diameter
9	Crosstube Lug	0.380Inches ± 0.030	0.410 0.350	Radius
10	Crosstube Lug	0.380Inches ± 0.030	0.410 0.350	
11	Crosstube Lug	0.625Inches ± 0.010	0.635 0.615	
12	Crosstube Lug	0.375Inches ± 0.010	0.385 0.365	
13	Crosstube Lug	3.700Inches ± 0.010	3.710 3.690	
14	Crosstube Lug	0.625Inches ± 0.010	0.635 0.615	
15	Crosstube Lug	0.375Inches ± 0.010	0.385 0.365	
16	Crosstube Lug	0.340Inches ± 0.030	0.370 0.310	Radius

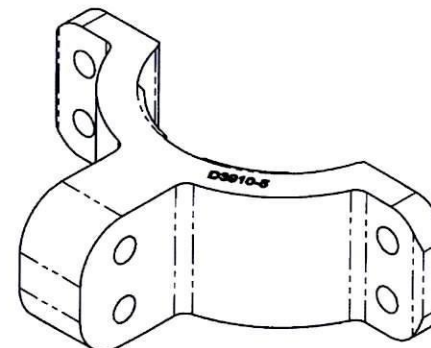
Plex 2/2/18 12:51 PM dart.baker.diane



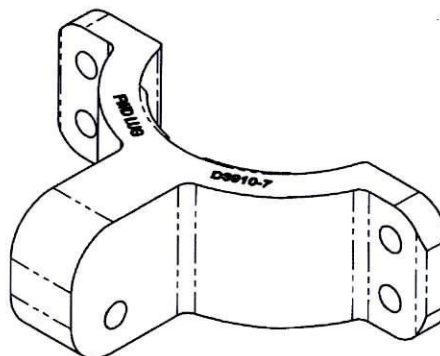
D3910-1 X-TUBE LUG



D3910-3 X-TUBE LUG



D3910-5 X-TUBE LUG



D3910-7 X-TUBE LUG

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 $\pm$ 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 $\pm$ 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs
-5: 0.36 lbs
-7: 0.37 lbs
- 8) IDENTIFICATION: ENGRAVE "FWD LUG" TO A DEPTH OF 0.010 $\pm$ 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 $\pm$ 0.005

RELEASED

2014 JUN 05

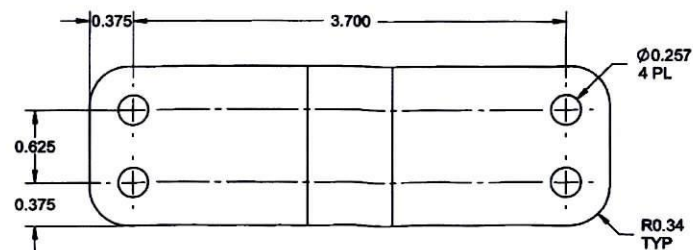
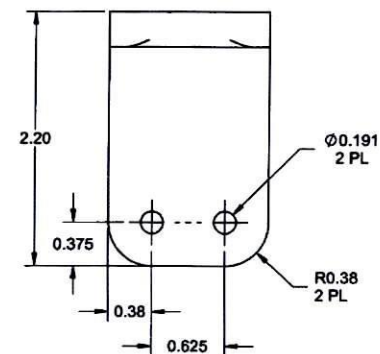
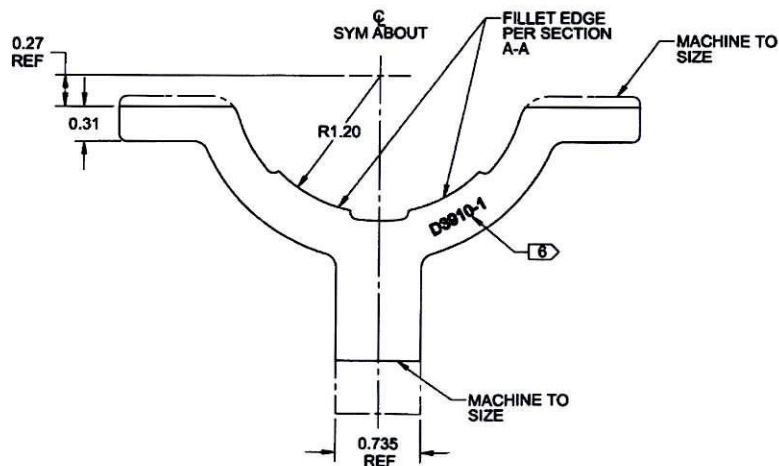
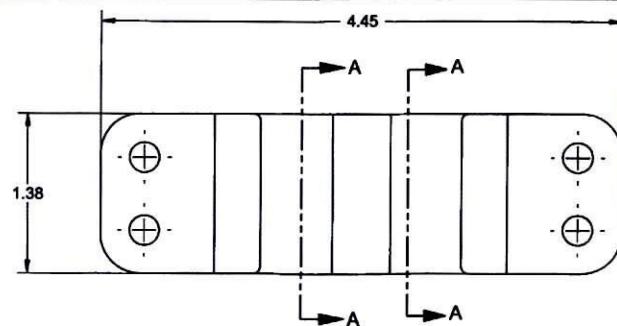
ECN 14-572

E	ADD -7 PER NCR14-3871	AJS	14.05.16
D	CHANGED FASTENER HOLES IN -5 FOR 1/4" HARDWARE. REASON: EASE OF INSTALLATION.	AJS	13.08.14
C	ADD -5.	AJS	13.08.08
B	Ø0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D3910-507-2	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JPH	DRAWING NO.	REV. E
MFG. APPR.	JPH	D3910	SHEET 1 OF 5
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	X-TUBE LUG (350)	NTS
DATE	14.05.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



ROUND EDGE
R0.08 MIN - R0.10 MAX
2 PL

SECTION A-A



D3910-1 X-TUBE LUG

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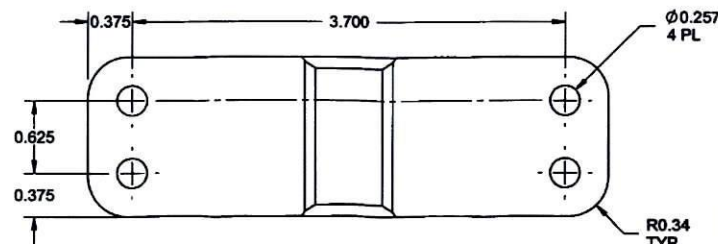
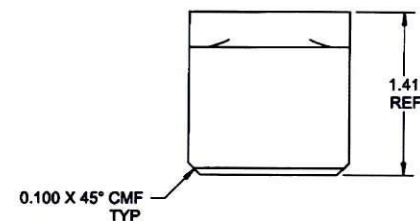
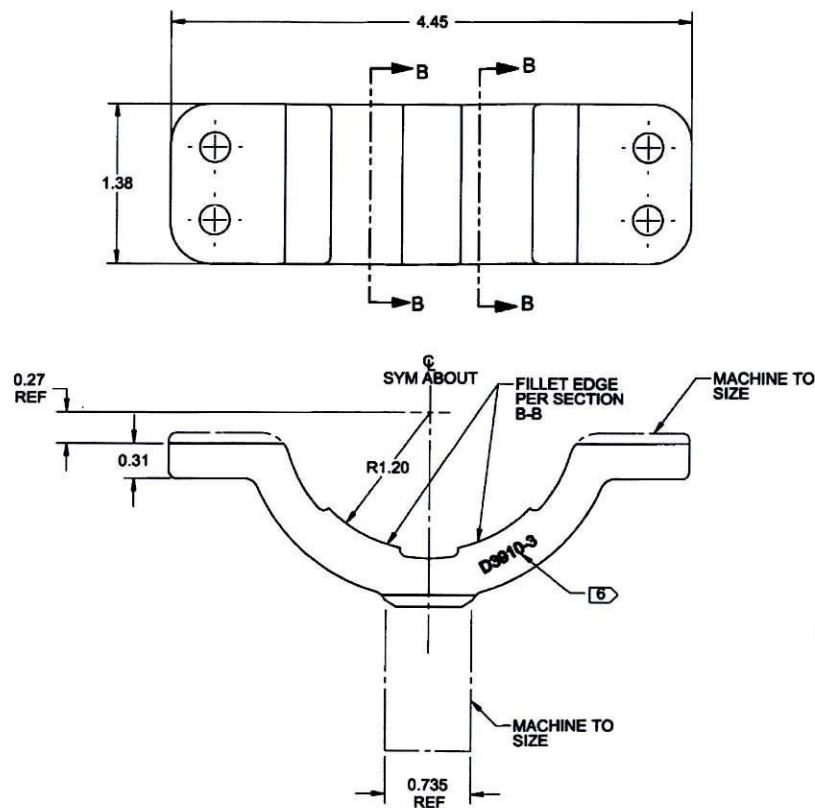
2014 JUN 05 *q*

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3910	REV. E SHEET 2 OF 5
MFG. APPR.	<i>[Signature]</i>	TITLE X-TUBE LUG (350)	SCALE NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	14.05.16		

SECTION B-B



ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL



D3910-3 X-TUBE LUG

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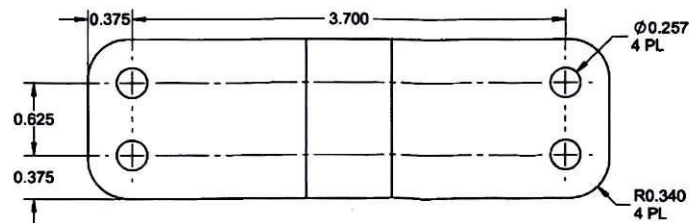
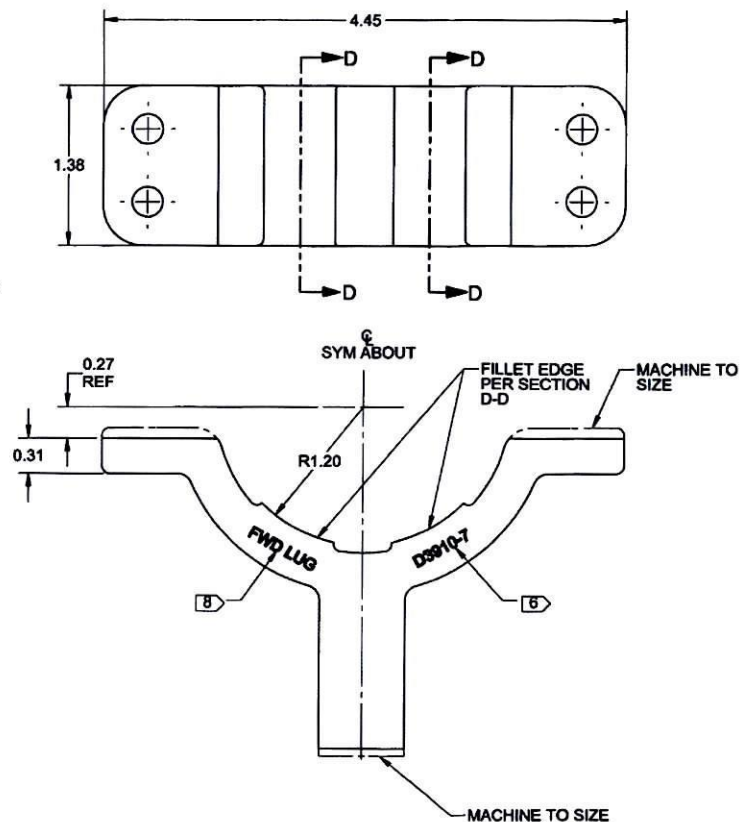
2014 JUN 05

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	J	DRAWING NO.	REV. E
MFG. APPR.	4/	D3910	SHEET 3 OF 5
APPROVED	4/	TITLE	SCALE
DE APPR.	4/	X-TUBE LUG (350)	NTS
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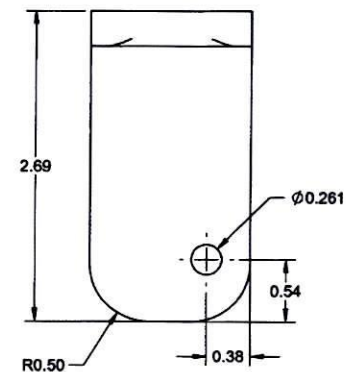
SECTION D-D



ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL



D3910-7 X-TUBE LUG



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2014 JUN 05

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D3910	REV. E
MFG. APPR.	<i>[Signature]</i>	SHEET 5 OF 5	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	X-TUBE LUG (350)	NTS
DATE	14.05.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038937

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO038937
PO Date: 2/2/18
Due Date: 2/16/18
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

E-MAILED

FEB 02 2018

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Items											
Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	D3910-1P			Crosstube Lug As Per Dwg D3910 Rev. E Alodine and Paint as pe QSI 005	Firmed	2/16/18	30 pcs ✓	0 pcs 30x	30 pcs DAS 38 9-22	\$16.10/pcs	\$483.00 DAS 17 9-22
Line Item Note job# 171541											
2	D4091-1P			Lug As Per Dwg D4091 Rev. A	Firmed	2/16/18	30 pcs ✓	0 pcs 30x	30 pcs	\$16.10/pcs	\$483.00
Line Item Note job# 171542											
Grand Total:											\$966.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

CL
DAB



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
30	D3910-1	Lug Paint Batch # 21566 Material B160522	38937
30	D4091-1	Lug Paint Batch # 21905 Material B148835	38937

Material supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Heather Nixon

Vankleek Hill, February 5, 2018